

Stat-Tech™ PC-10CF/000 FR V0 BK035

Polycarbonate
PolyOne Corporation

Message:
Carbon Fiber Filled, Non-halogen Containing Flame Retardant Polycarbonate Compound

General Information			
UL YellowCard	E76261-102389285		
Filler / Reinforcement	Carbon fiber reinforced material, 10% filler by weight		
Features	Halogen-free		
	Flame retardancy		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792
Molding Shrinkage (3.00 mm)	0.20 - 0.40	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	100	MPa	ASTM D638
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Flexural Modulus ³	6500	MPa	ASTM D790
Flexural Strength ⁴	150	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm, Injection Molded)	70	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	144	°C	ASTM D648
1.8 MPa, not annealed	137	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+4 - 1.0E+6	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	V-0		UL 94
3.00 mm	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	110 - 130	°C	
Drying Time	4.0 - 6.0	hr	
Processing (Melt) Temp	280 - 310	°C	

Mold Temperature	80.0 - 120	°C
Injection instructions		
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW		
NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	

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